

# Work Order ID 84790

\*84790\*

Page 1

May-23-12 10:48:30 AM

Item ID: D206-642-441 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Replacement Skidtube  
 Start Date: 5/23/12 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 5/24/12 Req'd Qty: 1.00 \*1\* Customer:  
 Reference: rework to CHG003

Approvals: Process Plan: W Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2650	Rev F								

100

0.00

\*100\*

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-441 CHG003

W 12 06 04

MLJ 12/06/04

<b>DART</b>		TEL: 1-613-632-8336 FAX: 1-613-632-4443	
TRANSPORT CANADA APPROVAL # 09-89			
P/N	D206-642-441	CHG	CHG002
DESC	Replacement Skidtube	STC	SH98-4
LOT	B30940	STC	SA00475SE
MODEL	206L/L1/L3/L4	STC	
US PATENT # 5,755,188 CANADA FOREIGN PATENTS PENDING		MADE IN CANADA	

**\*84790\***

May-23-12 10:48:30 AM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 5/23/12      **Start Qty:** 1.00      **\*1\***

**Cust Item ID:**

**Required Date:** 5/24/12      **Req'd Qty:** 1.00      **\* 1 \***

**Customer:**

**Reference:** rework to CHG003

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230

0.00

**\*230\***

## HandFinishing

0.00

HandFinish

## Hand Finishing

## Memo

PULL FROM STK:

1 X D206-642-441 B30940

UPDATE TO CHG003 PER& 09-531 DSI9440

REMOVE WEARPLATES:

6 X D2648-3 B29777

1 X D2656-15 B29335

1 X D2656-23 B29336

1 X D2656-37 B29338

1 X D3429-1 B30237

RETURN TO STK

RETURN TO STR  
DISCARD HARDWARE

ADD:

6 X D3537-1 B

1 X D3537-3 B

1 X D3535-15 B

1 X D3536-15 B

1 X D3535-23 B \_\_\_\_\_

1 X D3536-23 B \_\_\_\_\_

1 X D3536-37 B \_\_\_\_\_

1 X D3536-37 B \_\_\_\_\_

60 X MS27039C1-08 B

60 X AN960C10L (NAS1149C0332R)

B

# Work Order ID 84790

**\*84790\***

Page 3

May-23-12 10:48:30 AM

Item ID: D206-642-441 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Replacement Skidtube  
Start Date: 5/23/12 Start Qty: 1.00 **\*1\*** Cust Item ID:  
Required Date: 5/24/12 Req'd Qty: 1.00 **\*1\*** Customer:  
Reference: rework to CHG003

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC5- Inspect part completeness to step on W/O	0.00							
<b>*240*</b>									
QC	Memo	0.00							
Quality Control									
250		0.00							
<b>*250*</b>	Packaging								
Packaging	Memo	0.00							
Packaging	REPACKAGE PER PPP USING NEW B/N NEW LABELS AND PAPERWORK REQ'D Identify and pack for shipping as per PPP D206-642-441 Location: _____ PPP Rev: _____								
260	QC21- Final Inspection - Work Order Release	0.00							
<b>*260*</b>									
QC	Memo	0.00							
Quality Control									

10/24/12  
12/6/12

12-06-7

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May-23-12 10:48:30 AM

Page 1

Work Order ID: 84790  
Parent Item: D206-642-441  
Parent Item Name: Replacement Skidtube

Start Date: 5/23/12  
Start Qty: 1.00  
Required Date: 5/24/12  
Required Qty: 1.00

Comments: IPP Rev:H05.10.11Added D3429-1 per CHG002 KJ/CP/JLM  
IPP Rev:I 08-05-01 add QC3 DD verified by:EC  
IPP Rev:J 08-09-29 revF as per dwg DD verified by: EC IPP rev K 10.09.27 SS washers  
for wearplates EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-642-441 Replacement Skidtube		Manufactured	No				Each	0.0000		1			
D2648-3 Wearpad		Manufactured	No				Each	19.0000		<del>2P</del> -6		12/05/29.	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST 29777 ✓		-18				6			
				81513		1							
				ST237A		19							
				ST497A		18							
				82819		18							
D2656-15 Wearshoe		Manufactured	No				Each	6.0000		<del>1</del> <del>2P</del>		12/05/29.	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP 29335 ✓		5				1			
				83601		5							
				Mezz		1							
				51455		1							
D2656-23 Wearshoe		Manufactured	No				Each	9.0000		<del>1</del> <del>2P</del>		12/05/29.	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz 29336 ✓		9				1			
				43407		2							
				51468		7							

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May-23-12 10:48:30 AM

Page 2

Work Order ID: 84790

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 5/23/12

Required Date: 5/24/12

Start Qty: 1.00

Required Qty: 1.00

D2656-37 Manufactured No Each 21.0000  
Wearshoe

Location	Loc Qty	Loc Code
Mezz 29338 ✓	21	
34510	2	
44550	7	
46497	1	
53019	11	

-1 (2P) 12/05/29

D3429-1 Manufactured No Each 16.0000  
Wearpad

Location	Loc Qty	Loc Code
FP002 30237	16	
40438	2	
43706	1	
44579	12	
65692	1	

-1 (2P) 12/05/29

D3535-15 Manufactured No Each 15.0000  
Wearshoe

Location	Loc Qty	Loc Code
FP001	15	
80328	2	
81354 ✓	13	

1

D3535-23 Manufactured No Each 20.0000  
Wearshoe

Location	Loc Qty	Loc Code
FP001	20	
81355	1	
83375 ✓	19	

1 (2P) 12/05/29

D3535-37 Manufactured No Each 4.0000  
Wearshoe

Location	Loc Qty	Loc Code
FP001	4	
71668 ✓	4	

1 (2P) 12/05/29

(2P) 12/05/29

May-23-12 10:48:30 AM

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Page 2

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May-23-12 10:48:30 AM

Page 3

Work Order ID: 84790

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 5/23/12

Required Date: 5/24/12

Start Qty: 1.00

Required Qty: 1.00

D3536-15 Manufactured No Each 18.0000  
Gasket

1 (2P) 12/05/29

Location	Loc Qty	Loc Code
FP002	18	
73318 ✓	14	
81343	4	

D3536-23 Manufactured No Each 14.0000  
Gasket

1 (2P) 12/05/29

Location	Loc Qty	Loc Code
FP002	14	
74510	1	
83377 ✓	13	

D3536-37 Manufactured No Each 19.0000  
Gasket

1 (2P) 12/05/29

Location	Loc Qty	Loc Code
FP002	19	
66823 ✓	7	
82623	12	

D3537-1 Manufactured No Each 91.0000  
Wearpad

6 (2P) 12/05/29

Location	Loc Qty	Loc Code
FG	10	
79833	10	
FP002	81	
69817	5	
81360 ✓	50	
81362	22	
83254	1	
83255	3	

May-23-12 10:48:30 AM

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Page 3

⑤ 1.1.1

⑥ 1.1.2

⑦ 1.1.3

⑧ 1.1.4

⑨ 1.1.5

⑩ 1.1.6

# Picklist Print

May-23-12 10:48:30 AM

Page 4

Work Order ID: 84790

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 5/23/12

Required Date: 5/24/12

Start Qty: 1.00

Required Qty: 1.00

D3537-3 Manufactured No  
Wearpad

Each 26.0000

1

(20) 12/05/29

Location	Loc Qty	Loc Code
FP002	26	
788360	4	
81363	22	

MS27039C1-08 Purchased No  
SCREW

Each 1,142.0000

60

(20) 12/05/29

Location	Loc Qty	Loc Code
FP002	1	
116022	1	
ST292	1122	
120308	354	
121068	108	
121162	660	
ST293	19	
116373	3	
118077	14	
119309	2	

NAS1149C0332R Washer Purchased No

Each 3,196.0000

60

(20) 12/05/29

Location	Loc Qty	Loc Code
ST297	219	
119736	196	
120648	23	
ST298	2977	
121255	11	
121509	2966	

May-23-12 10:48:30 AM

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Page



# **DART SERVICE INSTRUCTION**

TO AMEND INSTALLATION INSTRUCTIONS D206-642 REV. L AND  
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-642 REV. 1

REF. CANADIAN STC: SH98-4

REF. FAA STC: SA00475SE

REF. EASA STC: EASA.IM.R.S.01320

84788 - 35469  
84789 - 31066  
84790 - 30440

## **INSTRUCTIONS:**

1) FOR D206-642-111/-112/-211/-212/-213/-214 SKIDTUBES @ CHANGE 005 AND SUBSEQUENT, MODIFY THE FOLLOWING:

- a) REPLACE THE CARBON STEEL WEAR PADS AND WEARSHOES WITH STAINLESS STEEL WEARPADS AND WEARSHOES PER THE UPDATED PARTS LIST ON SHEET 2.
- b) ADD NEOPRENE GASKETS BETWEEN THE SKIDTUBE AND WEARSHOES PER THE UPDATED PARTS LIST ON SHEET 2 AND PER FIGURE 1 ON SHEET 4.
- c) REPLACE THE CARBON STEEL FASTENERS FOR THE WEARPADS AND WEARSHOES WITH STAINLESS STEEL FASTENERS PER THE UPDATED PARTS LIST ON SHEET 2.
- d) AMEND THE PARTS LIST IN SECTIONS 4.1 AND 4.2 OF INSTALLATION INSTRUCTIONS D206-642 REV. L OR EARLIER AND SECTIONS 32.10 AND 32.11 OF THE INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-642 REV. 1 OR EARLIER AS SHOWN ON SHEET 2.

2) FOR D206-642-311/-312/-411/-412 SKIDTUBES @ CHANGE 006 AND SUBSEQUENT, MODIFY THE FOLLOWING:

- a) REPLACE THE CARBON STEEL WEAR PADS AND WEARSHOES WITH STAINLESS STEEL WEARPADS AND WEARSHOES PER THE UPDATED PARTS LIST ON SHEET 3.
- b) ADD NEOPRENE GASKETS BETWEEN THE SKIDTUBE AND WEARSHOES PER THE UPDATED PARTS LIST ON SHEET 3 AND PER FIGURE 2 ON SHEET 4.
- c) REPLACE THE CARBON STEEL FASTENERS FOR THE WEARPADS AND WEARSHOES WITH STAINLESS STEEL FASTENERS PER THE UPDATED PARTS LIST ON SHEET 3.
- d) AMEND THE PARTS LIST IN SECTIONS 4.3 AND 4.4 OF INSTALLATION INSTRUCTIONS D206-642 REV. L OR EARLIER AND SECTIONS 32.12 AND 32.13 OF THE INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-642 REV. 1 OR EARLIER AS SHOWN ON SHEET 3.

B	P/N CORRECTION	AJS	09.03.25
A	NEW ISSUE	AJS	08.12.19
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>JS</del>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9440	SHEET 1 OF 4
APPROVED	<del>JS</del>	TITLE	SCALE
DE APPR.	<del>JS</del>	WEARSHOE CHANGE	NTS
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4.1 206 A/B Low Gear Skidtubes (D206-642)  
32.10 206 A/B Low Gear Skidtubes (ICA-D206-642)

ITEM	Qty -111	Qty -112	Qty -141	Qty -147	PART NUMBER	DESCRIPTION
	X				D206-642-111	SKIDTUBE INSTALLATION, LH
		X			D206-642-112	SKIDTUBE INSTALLATION, RH
	1	1	X		D206-642-141	SKIDTUBE
				X	D206-642-147	WEARSHOE KIT (REPLACES -143)
	1	1			D206-651-041	* 206 GHW ADAPTER <sup>20</sup>

IS:

20A			4		D3537-1	WEARPAD (REPLACES D2648-3)	(MODIFY)
21A			1		D3537-3	WEARPAD (REPLACES D3429-1)	(MODIFY)
22A			1	1	D3535-11	WEARSHOE (REPLACES D2656-11)	(MODIFY)
22B			1	1	D3536-11	GASKET	(ADD)
23A			1	1	D3535-21	WEARSHOE (REPLACES D2656-21)	(MODIFY)
23B			1	1	D3536-21	GASKET	(ADD)
24A			1	1	D3535-31	WEARSHOE (REPLACES D2656-31)	(MODIFY)
24B			1	1	D3536-31	GASKET	(ADD)
26A			42		MS27039-1C08	SCREW	(MODIFY)
26B			42		AN960C10L	WASHER	(MODIFY)

WAS:

20A			4		D2648-3	WEARPAD
21A			1		D3429-1	WEARPAD
22A			1	1	D2656-11	WEARSHOE
23A			1	1	D2656-21	WEARSHOE
24A			1	1	D2656-31	WEARSHOE
26A			42		MS27039-1-08	SCREW
26B			42		AN960JD10L	WASHER

4.2 206 A/B High Gear Skidtubes (D206-642)  
32.11 206 A/B High Gear Skidtubes (ICA-D206-642)

ITEM	Qty -211	Qty -212	Qty -213	Qty -214	Qty -241	Qty -247	PART NUMBER	DESCRIPTION
	X						D206-642-211	SKIDTUBE INSTALLATION, LH
		X					D206-642-212	SKIDTUBE INSTALLATION, RH
			X				D206-642-213	SKIDTUBE INSTALLATION, LH, THRU BOLT
				X			D206-642-214	SKIDTUBE INSTALLATION, RH, THRU BOLT
	1	1	1	1	X		D206-642-241	SKIDTUBE
						X	D206-642-247	WEARSHOE KIT (REPLACES -243)
	1	1	1	1			D206-651-041	* 206 GHW ADAPTER <sup>20</sup>

IS:

20A					4		D3537-1	WEARPAD (REPLACES D2648-3)	(MODIFY)
21A					1		D3537-3	WEARPAD (REPLACES D3429-1)	(MODIFY)
22A					1	1	D3535-13	WEARSHOE (REPLACES D2656-13)	(MODIFY)
22B					1	1	D3536-13	GASKET	(ADD)
23A					1	1	D3535-21	WEARSHOE (REPLACES D2656-21)	(MODIFY)
23B					1	1	D3536-21	GASKET	(ADD)
24A					1	1	D3535-33	WEARSHOE (REPLACES D2656-33)	(MODIFY)
24B					1	1	D3536-33	GASKET	(ADD)
26A					44		MS27039-1C08	SCREW	(MODIFY)
26B					44		AN960C10L	WASHER	(MODIFY)

WAS:

20A					4		D2648-3	WEARPAD
21A					1		D3429-1	WEARPAD
22A					1	1	D2656-13	WEARSHOE
23A					1	1	D2656-21	WEARSHOE
24A					1	1	D2656-33	WEARSHOE
26A					44		MS27039-1-08	SCREW
26B					44		AN960JD10L	WASHER

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9440	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE CHANGE	NTS
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4.3 206 L/L-1/L-3/L-4/407 Low Gear & 407 High Gear Skidtubes (D206-642)  
32.12 206 L/L-1/L-3/L-4/407 Low Gear & 407 High Gear Skidtubes (ICA-D206-642)

ITEM	Qty -311	Qty -312	Qty -341	Qty -347	Qty -013	PART NUMBER	DESCRIPTION
	X					D206-642-311	SKIDTUBE INSTALLATION, LH
		X				D206-642-312	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-341	SKIDTUBE
				X		D206-642-347	WEARSHOE KIT (REPLACES -343)
	1	1			X	D206-648-013	GROUND HANDLING KIT

IS:

20A			6			D3537-1	WEARPAD (REPLACES D2648-3)	(MODIFY)
21A			1			D3537-3	WEARPAD (REPLACES D3429-1)	(MODIFY)
22A			1	1		D3535-11	WEARSHOE (REPLACES D2656-11)	(MODIFY)
22B			1	1		D3536-11	GASKET	(ADD)
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)	(MODIFY)
23B			1	1		D3536-23	GASKET	(ADD)
24A			1	1		D3535-35	WEARSHOE (REPLACES D2656-35)	(MODIFY)
24B			1	1		D3536-35	GASKET	(ADD)
26A			54			MS27039-1C08	SCREW	(MODIFY)
26B			54			AN960C10L	WASHER	(MODIFY)

WAS:

20A			6			D2648-3	WEARPAD
21A			1			D3429-1	WEARPAD
22A			1	1		D2656-11	WEARSHOE
23A			1	1		D2656-23	WEARSHOE
24A			1	1		D2656-35	WEARSHOE
26A			54			MS27039-1-08	SCREW
26B			54			AN960JD10L	WASHER

4.4 206L/L-1/L-3/L-4 High Gear Skidtubes (D206-642)  
32.13 206L/L-1/L-3/L-4 High Gear Skidtubes (ICA-D206-642)

ITEM	Qty -411	Qty -412	Qty -441	Qty -447	Qty -013	PART NUMBER	DESCRIPTION
	X					D206-642-411	SKIDTUBE INSTALLATION, LH
		X				D206-642-412	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-441	SKIDTUBE
				X		D206-642-447	WEARSHOE KIT (REPLACES -443)
	1	1			X	D206-648-013	GROUND HANDLING KIT

IS:

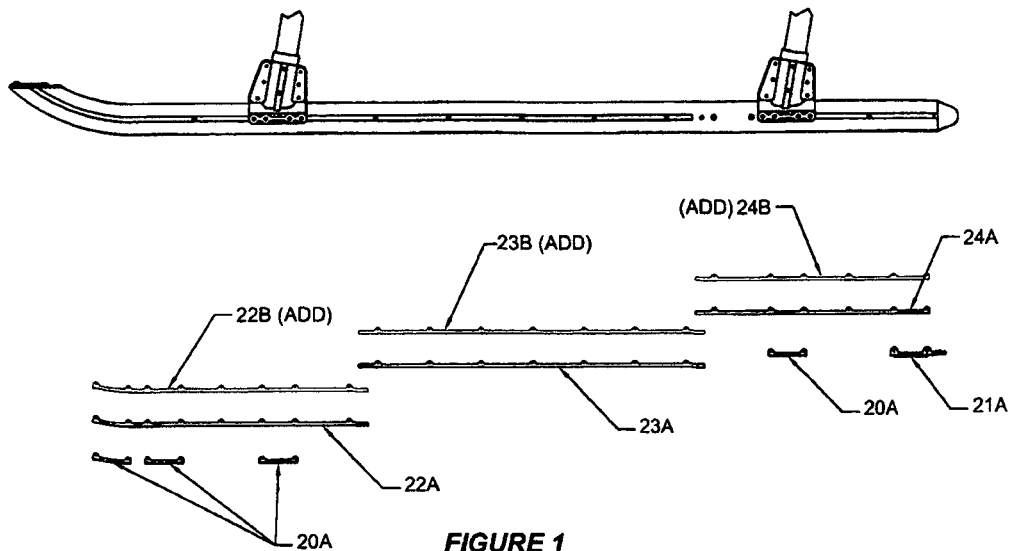
20A			6			D3537-1	WEARPAD (REPLACES D2648-3)	(MODIFY)
21A			1			D3537-3	WEARPAD (REPLACES D3429-1)	(MODIFY)
22A			1	1		D3535-15	WEARSHOE (REPLACES D2656-15)	(MODIFY)
22B			1	1		D3536-15	GASKET	(ADD)
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)	(MODIFY)
23B			1	1		D3536-23	GASKET	(ADD)
24A			1	1		D3535-37	WEARSHOE (REPLACES D2656-37)	(MODIFY)
24B			1	1		D3536-37	GASKET	(ADD)
26A			60			MS27039-1C08	SCREW	(MODIFY)
26B			60			AN960C10L	WASHER	(MODIFY)

WAS:

20A			6			D2648-3	WEARPAD
21A			1			D3429-1	WEARPAD
22A			1	1		D2656-15	WEARSHOE
23A			1	1		D2656-23	WEARSHOE
24A			1	1		D2656-37	WEARSHOE
26A			60			MS27039-1-08	SCREW
26B			60			AN960JD10L	WASHER

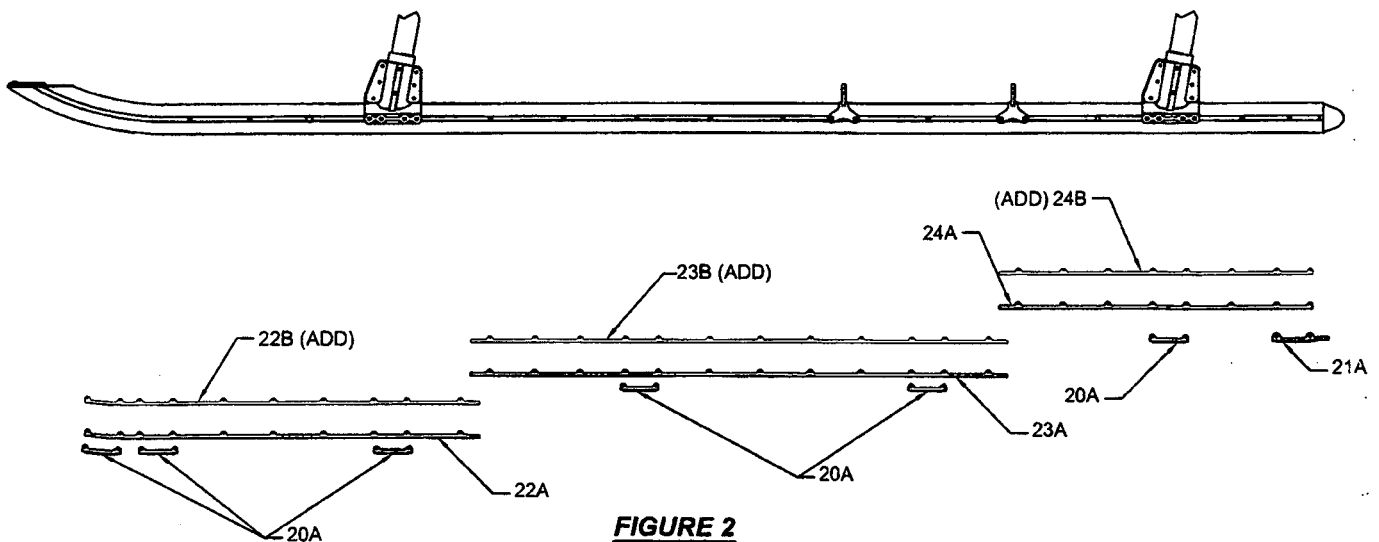
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<del>---</del>	DRAWING NO.	REV. 3
MFG. APPR.	N/A	DSI 9440	SHEET 3 OF 4
APPROVED	<del>---</del>	TITLE	SCALE
DE APPR.	<del>---</del>	WEARSHOE CHANGE	NTS
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**206 A/B SKIDTUBES**  
(D206-642-111/-112/-211/-212/-213/-214)



**FIGURE 1**

**206 L/L-1/L-3/L-4/407 SKIDTUBES**  
(D206-642-311/-312/-411/-412)



**FIGURE 2**

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9440	SHEET 4 OF 4
APPROVED		TITLE	SCALE
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Part Number DZ06-642-441  
Description 206 SKID TUBE

Part Number D206-642-441  
Description 206 SKIDTUBE

17:25min-03:10formalChance, Robert A

200-2

## List Lots

May-23-12 9:24:04 AM

Page 1 of 1

Criteria : Item ID: d206-642-441 All Locations All Warehouses All Quantity							
Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt Lot Code	Type Code	Comments
D206-642-441 Replacement Skidtube	Main Warehouse FG080	30940	5/11/12	1.0000	QC21	CHG002	
	Main Warehouse FG080	31066	5/11/12	1.0000	QC21	CHG002	
	Main Warehouse FG080	35469	5/11/12	1.0000	QC21	CHG002	
Total:				3.0000			

Date: Friday, 2/23/2007 1:56:52 PM  
User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206 L HIGH GEAR SKIDTUBE  
Job Number : 30940  
Estimate Number : 10522  
P.O. Number : N/A Part Number : D206642441  
This Issue : 2/23/2007 S.O. No. : N/A Drawing Number : D2650 REV E  
Prsht Rev. : NC Project Number : N/A  
First Issue : N/A Type : LANDING GEAR Drawing Revision : E  
Previous Run : 30939A Material : N/A Due Date : 3/30/2007 Qty: 1 Um: Each  
Written By :  
Checked & Approved By : H07.02.26  
Comment : Est Rev: 05.10.11 Added D3429-1 per CHG004 K/J/CP/JL  
M

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-441 CHG002

HAS NEW 700 / MMS  
K-3 07-03-22

2.0

D2620

Bent 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2620 Bent Tube 3" OD

29388 Pnc 07-03-07 ①

3.0

D2647

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2647 Fwd Cap

B22320 BE 07-03-08

4.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube (M 07-03-07 ①)

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650 (M 07-03-07 ①)

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R Aluminum Rod M103317/M102421 BE 07-03-08

4-Grind weld flush to cap on top surface only.

BE 07-03-08

Date: Friday, 2/23/2007 1:56:52 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 30940

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description:

5-Cut aft end 138.60" from front of tube *Pm 07-03-080*

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312" *Pm 07-03-081*

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297" *Pm 07-03-090*

8-Open using #6 Drill Bit *Pm 07-03-090*

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail *Pm 07-03-090*

10-Remove inner indexing ridge on aft end of skidtube as per Dwg D2650 *Pm 07-03-090*

11-Deburr and Blow out all chips from inside the tube *Pm 07-03-090*

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 *Pm 07-03-090*

6.0

D26547

206 L Beam (Web)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2654-7

Web

*B 30785*

*JD 7-3-19*

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail (without cutting fluid) *Pm 07-03-160*

2-Countersink crossbolt spacer holes as per Dwg D2650 (without cutting fluid) *Pm 07-03-160*

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer. *Pm 07-03-160*

4-Bond D2654-7 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs. cure time before cutting

Start Date: *7-3-19* Time: *11:00*

Finish Date: *7-3-21* Time: *9:15*

A/R Sikaflex-291 *M 103497*

Sikaflex expiry date: *7-10-1*

*JD 7-3-19*



Date: Friday, 2/23/2007 1:56:53 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 30940

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description:

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*BE 07-03-21*

9.0

D2649

Crossbolt Spacer



Comment: Qty.: 23.0000 Each(s)/Unit Total: 23.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

23 D2649

Crossbolt spacer

*B29329 BE 07-03-21*

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.  
A/R Aluminum Rod *M102421 BE 07-03-21*

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

*Pm 07-03-20*

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 Debur

*Pm 07-03-27 @*

11.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2680-041

Nut Plate

*B28935 Pm 07-03-27 @*

12.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 CCR264SS3-3

Rivets

*M103525 Pm 07-03-27 @*

13.0

M7885343

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

Date: Friday, 2/23/2007 1:56:53 PM  
User: Kirt Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 30940

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description:

2 M7885/3-4-3

Rivets

M19649

Pw-07-03-270

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

Pw-07-03-270

15.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

M-L

07/04/23

18.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White (Ref. 4.3.5.1) as per QSI 005 4.3

Make sure Nut Plate Thread protected use paint screw

HL

07-04-24 ①

19.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

20.0

D26483

Wearpad



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number

Description/ Batch

6 D2648-3

Wearpad

B29777

21.0

D265615

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description/ Batch

1 D2656-15

Wearshoe

B29335

FL

07/04/26 ①

Date: Friday, 2/23/2007 1:56:53 PM  
User: Kirn Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 30940

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

D265623

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-23

Wearshoe

B29336

23.0

D265637

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-37

Wearshoe

B29338

24.0

D34291



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3429-1

Wearpad

B20237

25.0

ALS41032130

Insert



Comment: Qty.: 60.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 ALS4-1032-130

Inserts

or (see QSI 017)

M102475

26.0

AN960JD10L

Washer



Comment: Qty.: 60.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 AN960JD10L

Washer

M102432

FL 07/04/25 0

Date: Friday, 2/23/2007 1:56:53 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 30940

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description:

27.0

MS27039108

Screw



Comment: Qty.: 60.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 MS27039-1-08

Screw

*m102630 (x5) m103641 (x55)*

28.0

D26511

Plug



Comment: Qty.: 22.0000 Each(s)/Unit Total: 22.0000 Each(s)

Pick:

Qty Part Number

Description Batch

22 D2651-1

Plugs

*B30943*

29.0

D26513

O-Ring



Comment: Qty.: 22.0000 Each(s)/Unit Total: 22.0000 Each(s)

Pick:

Qty Part Number

Description Batch

22 D2651-3

O-Rings

*B30815*

30.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 AN960JD416

Washer

*m103338*

31.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 MS27039-4-06

Screw

*m15194*

32.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

*FX 07/04/26 ①*

Date: Friday, 2/23/2007 1:56:53 PM  
User: Kirh Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 30940

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description:

1 D2646

Aft Cap B30119

33.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 AN960JD10L

Washer

m102837

Feb 07/04/26 ①

34.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 MS27039-1-08

Screw

m102630

35.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291

m103561

Sikaflex expiry date:

07/10

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R Sikaflex-291

m103561

Sikaflex expiry date:

07/10

6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4

Batch:

m103707

Feb 07/04/27 ①